

Date: Monday, 8/21/2006 2:12:16 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number	: 28263	Part Number	: D29332
Estimate Number	: 10834	Drawing Number	: D2933 REV B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 8/21/2006 S.O. No. : N/A	Drawing Revision	: B
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : MACHINED PARTS	Due Date	: 9/10/2006
Previous Run	: 27565	Qty:	8 Um: Each
Written By	: <u>                    </u>		
Checked & Approved By	: <u>                    </u>		
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC		

## Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

D6101001

7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)  
 Issue material from stock: 7075-T7351 QQ-A-250/12  
 Cut Size 2.0 x 6.25 X 6.00  
 Grain Along Long 6.00 Length  
 Batch No: 025344

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Program part number and batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 5-Deburr

SD/IL 06-09-10

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

SD 06-09-10

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SD/IL 06-09-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 06/05/18

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 8/21/2006 2:12:17 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 28263

Part Number: D29332

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/09/12 x 8

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

mm B 09 14

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 0609 15 (8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

P 6/9/18 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

stg70 P 6/9/18 (8)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/09/18 (8)

Job Completion



u 06/09/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 28263
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2933-2
<b>Inspection Dwg:</b> D2933 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.120	.120	.120	.121		
B	0.100	0.140		.119	.119	.119	.121		
C	0.100	0.140		.121	.125	.125	.128		
D	0.210	0.230		.221	.226	.226	.226		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.249	1.248	1.250	1.250		
G	2.495	2.505		2.499	2.499	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.576	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.121	.126	.126	.125		
O	0.540	0.560		.550	.549	.549	.550		
P	0.490	0.510		.501	.499	.500	.501		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.249	.250	.247	.250		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.125	1.145		1.135	1.139	1.139	1.136		
Y	1.565	1.585	DT8695 A/B	/	/	/	/		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by: J.L. / S.D.	Audited by: E.
Date: 06/09/08	Date: 06/09/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 28263
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2933-2
<b>Inspection Dwg:</b> D2933 Rev. B	<b>Page 1 of 1</b>

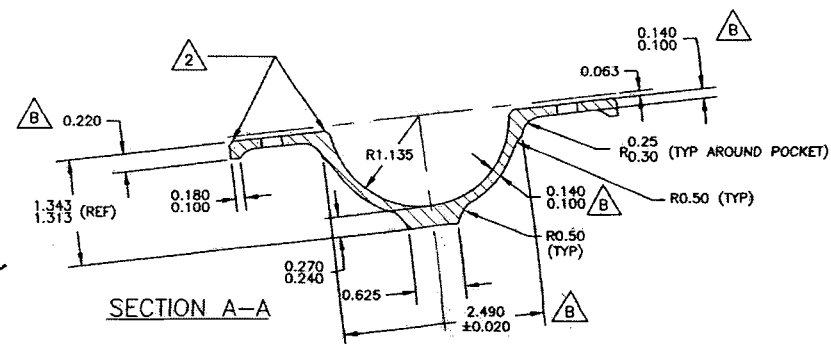
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.122	.122	.122	.123		
B	0.100	0.140		.121	.121	.121	.121		
C	0.100	0.140		.126	.129	.128	.129		
D	0.210	0.230		.225	.225	.225	.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.124	.124	.124	.124		
O	0.540	0.560		.550	.549	.550	.549		
P	0.490	0.510		.499	.498	.498	.499		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.250	.250	.251	.250		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690						
X	1.125	1.145		1.135	1.134	1.134	1.134		
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

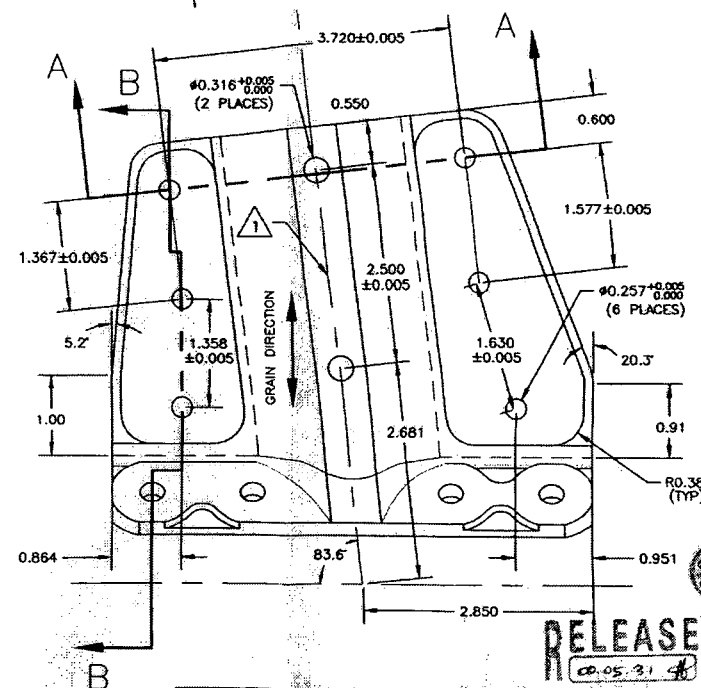
Measured by:	SD
Date:	06.09.09

Audited by:	En
Date:	06/09/12




Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#



## SECTION B-B

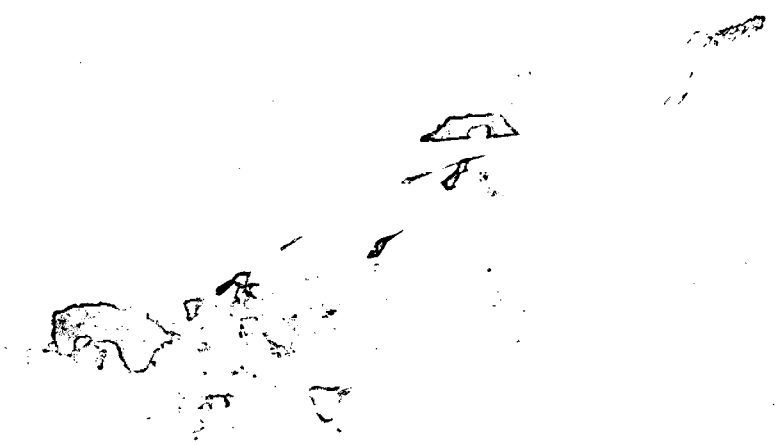


RELEASE  
00-05-31

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN 	DRAWN BY RF	<b>DART</b> DART AEROSPACE USA, INC. BELLUVE, WA
CHECKED 	APPROVED 	DRAWING NO. D2933 REV. 1 SHEET 1 OF 2
DATE 00.05.29		TITLE SADDLE INSIDE SCALE 2:

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